

Work Order ID 153168

Tuesday, November 08, 2016 2:28:25 PM

153168

Page 1

Item ID: D5380-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support Base
 Start Date: 11/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/11/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference: ECN 16-643

Approvals: Process Plan: dem Date: 16/11/8 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5380	B

150

150

Packaging

Packaging

Memo

PULL FROM STOCK

1 X D5380-3 B144116

0.00
SCRAP
 0.00

1 16-11-09

160

160

HAAS 1

HAAS CNC vertical machine #1

Memo

RE-WORK TO REV B AS PER ECN 16-643

AS per J.H.

0.00

CAN'T BE REWORKED.
16-11-09

1 16-11-09

170

170

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

FF NOV-9-16

DAS
38
9-88

NOV 09 2016

Work Order ID 153168

Tuesday, November 08, 2016 2:28:25 PM

153168

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo PUT BACK INTO STOCK AT REV B LOCATION: LG054	0.00 0.00							

Tuesday, November 08, 2016 2:28:25 PM

Page 3

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

~~Scrap!~~

Picklist Print

Page 1

Tuesday, November 08, 2016 2:28:25 PM

Work Order ID: 153168

153168

Parent Item: D5380-3

D5380-3

Parent Item Name: Support Base

Start Date: 11/8/2016

Required Date: 11/11/2016

Start Qty: 1.00

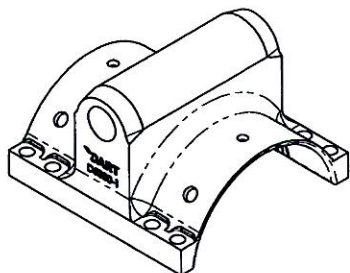
Required Qty: 1.00

Comments: IPP Rev: A New issue JFS 16/02/03 Verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5380-3		Manufactured	No				Each	0.0000		1			
D5380-3									**				
Support Base													

B144116

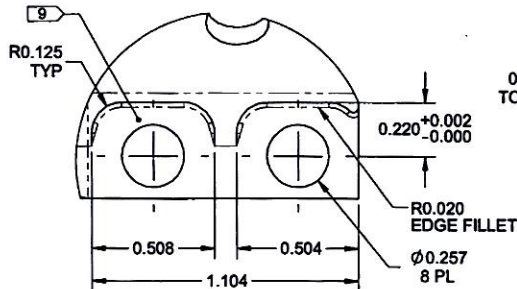
16-11-09



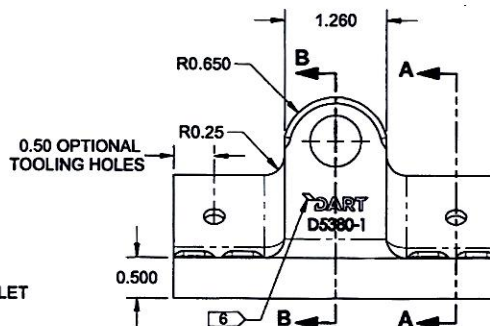
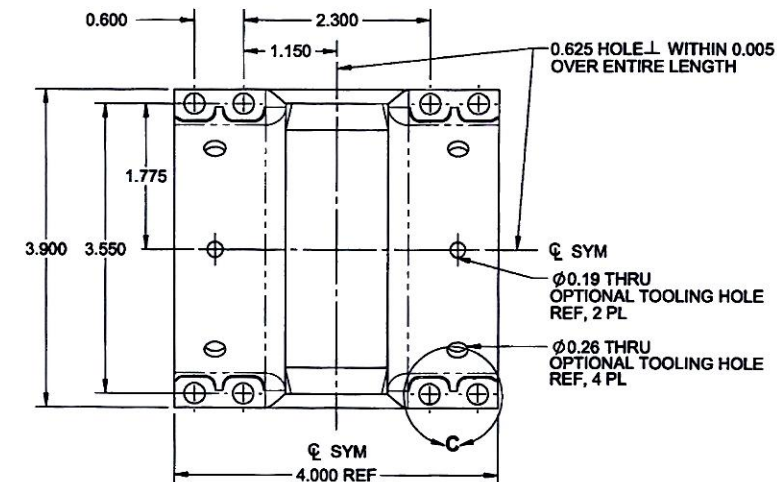
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 153168

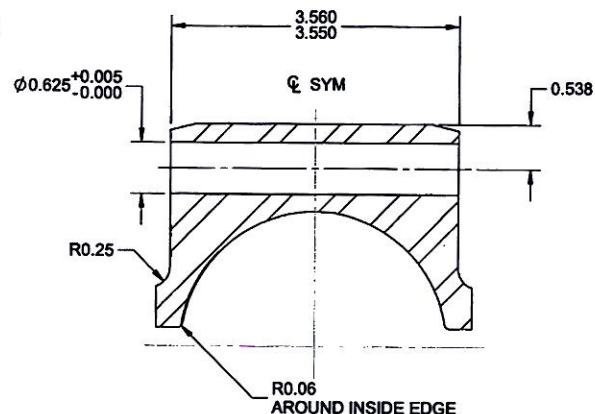
2m 16/11/8



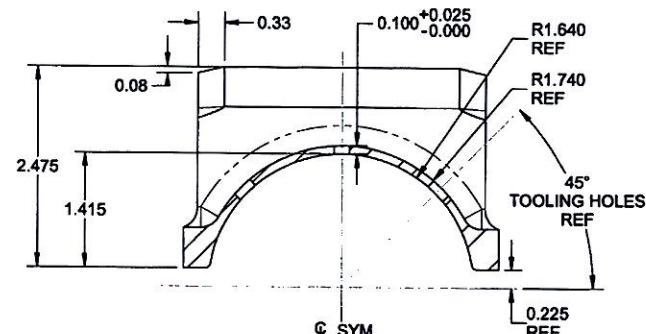
DETAIL C
SCALE 2X
4 PL



D5380-1 SUPPORT



SECTION B-B



SECTION A-A

RELEASED

2016 NOV 08
ECN 16-643

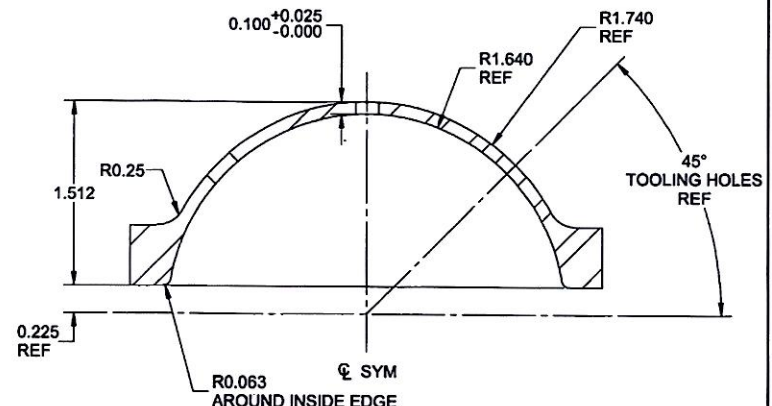
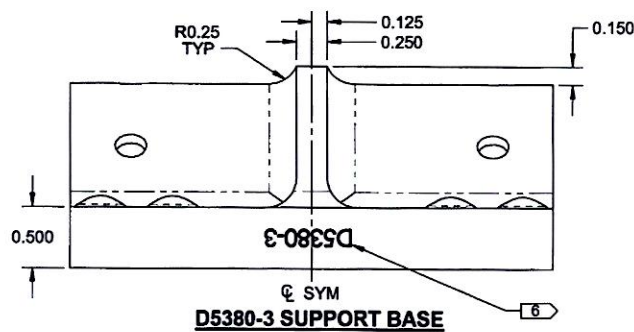
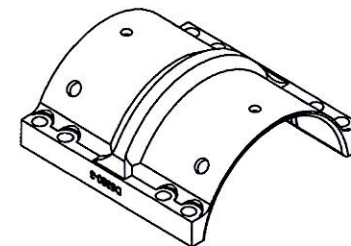
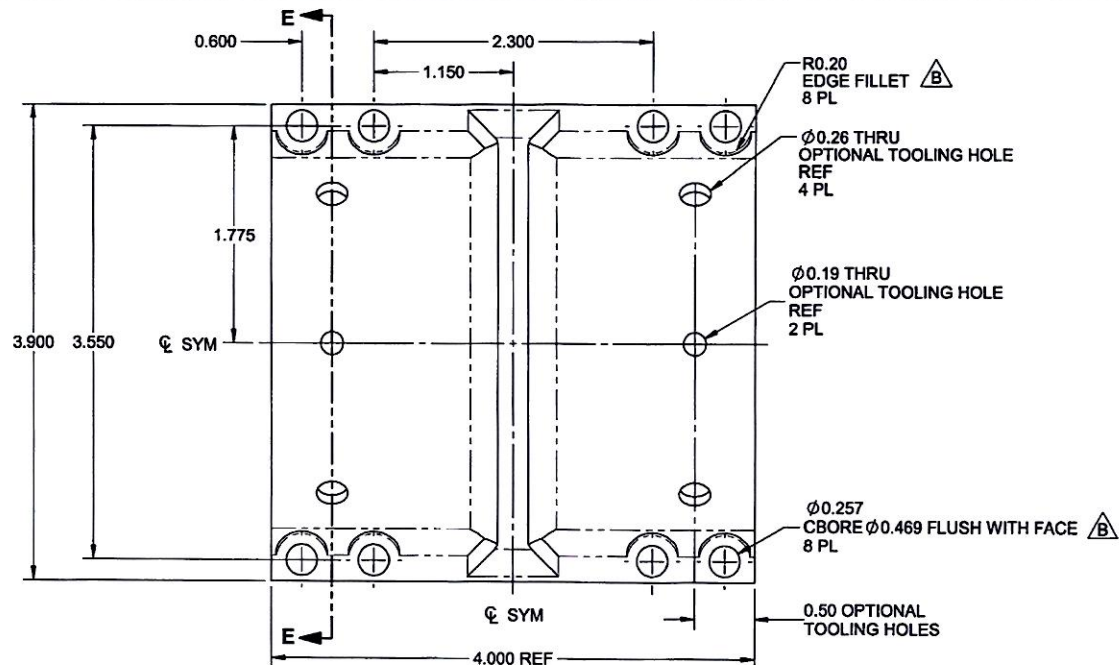
- NOTES:
- 1) MATERIAL: MAKE FROM D5380-1TRN
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING AND 0.005-0.010 DEEP PER DART QSI 044 6.3
 - 7) WEIGHT: 2.08 lbs
 - 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-1-REVB.STP"
 - 9) REMOVE MATERIAL FLUSH TO FACE

APPROVED

B	MODIFY -1 PROFILE IN DETAIL C, INCREASE HOLE DIAMETER TO 0.257, MODIFY -3 TO ADD CORNER RAD TO CBORE AND INCREASE CBORE DIAMETER; UPDATE NOTES	ML	16.07.07
A	NEW ISSUE	ML	16.01.05
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5380	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SUPPORT	NTS
DATE	16.07.07	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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- NOTES:
- 1) MATERIAL: MAKE FROM D5380-3TRN
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N WITH 0.125 HIGH LETTERING AND 0.005-0.010 DEEP PER DART QSI 044 6.3
 - 7) WEIGHT: 0.89 lbs
 - 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-3-REVB.STP"

RELEASED
2016 NOV 08

SECTION E-E

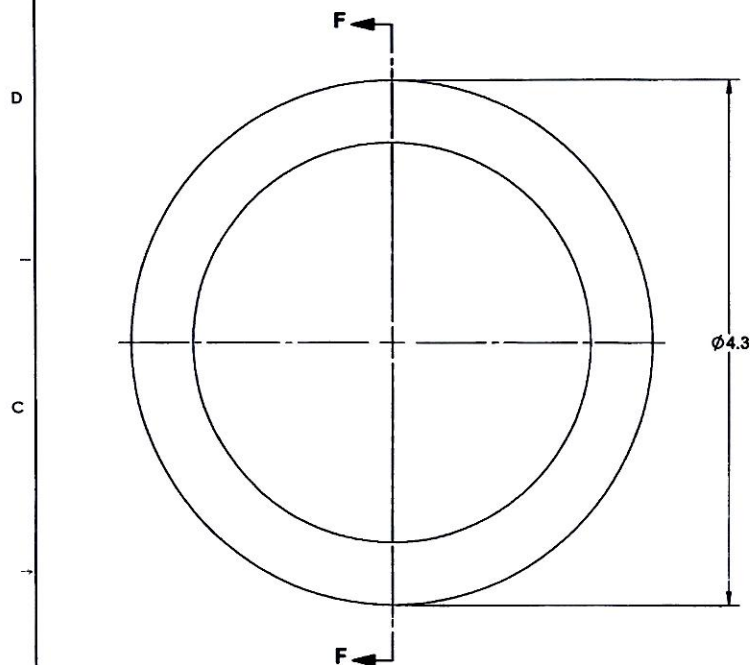
APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5380	SHEET 3 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SUPPORT	NTS
DATE	16.07.07		

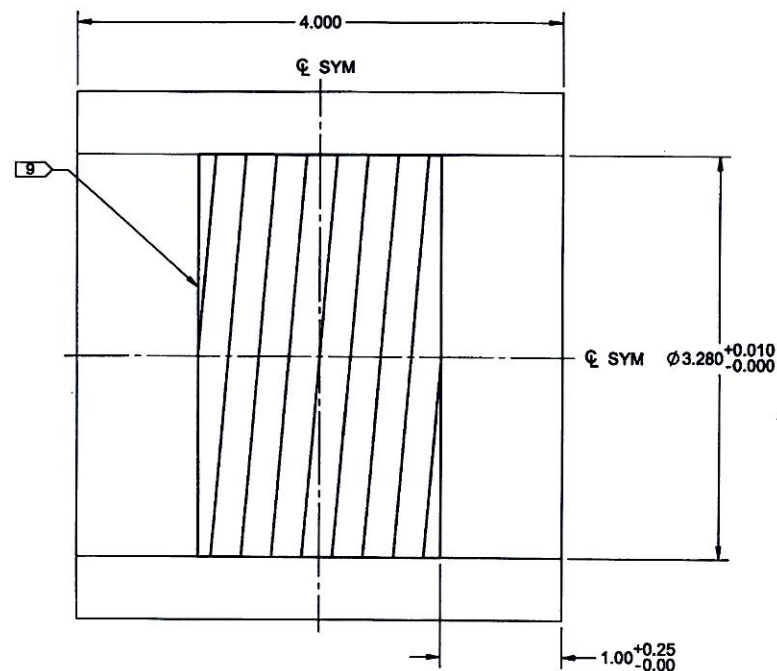
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8 7 6 5 4 3 2 1



D5380-3TRN



SECTION F-F

NOTES:

1) MATERIAL: 17-4 PH/S17400/TYPE 630 ROUND BAR PER AMS 5643 / ASTM A564
H900 OR H925 CONDITION, MIN UTS = 170 KSI (38 HRc)
REF DART SPEC. M17-4-R

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER DART QSI 044

7) WEIGHT: 7.02 lbs

8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-3TRN-REVB.STP"

9) SURFACE IS TO BE THREADED USING R0.032 TOOLING AT A DEPTH OF 0.032 $\frac{+0.010}{-0.016}$ WITH A PITCH OF 0.125 $\frac{+0.010}{-0.010}$

RELEASED

2016 NOV 08

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5380	SHEET 4 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SUPPORT	NTS
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8 7 6 5 4 3 2 1

List Lots

Page 1 of 1

Tuesday, November 08, 2016 12:49:51 PM

Criteria : Item ID: 'D5380-1', 'D5380-1TRN', 'D5380-3', 'D5380-3TRN' All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
D5380-1 Support	Main Warehouse prelim	144114	6/7/2016	1.0000		QC21		
			Total:	1.0000				
D5380-3 Support Base	Main Warehouse prelim	144116	6/7/2016	1.0000		QC21		153168
			Total:	1.0000				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By 		
							Lead hand / Supervisor Approval Verification 		
							QC / QA Coordinator Approval 		

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							